

Date: Monday, 11/19/2007 4:02:00 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT
 Job Number : 35822
 Estimate Number : 12577
 P.O. Number : N/A Part Number : D3562042
 This Issue : 11/19/2007 S.O. No. : N/A Drawing Number : D3562 UNDER REVIEW
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : C
 Previous Run : 35402 Material : N/A
 Due Date : 12/12/2007 Qty: 5 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A New Issue 06-11-09 JLM
 Est rev B ECN 987 07.10.09 EC verified by: DD

07.11.20 DC

OK PER REV. C

ENSURE D2808
SPACER IS PRESS FIT
BEFORE POWDER COAT.

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion

B34694

Check Material for any Dents or Defects

Q.N 07.11.20

5

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

Q.N

07-12-03

5

2-Deburr and bevel ends for welding

Q.N

07.12.03

5

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Q.N 12/12/03

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.N

07.12.04

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:02:00 PM
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Drawing Name: STEP WELDMENT

Job Number: 35822

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 12-07-12-17 5

6.0

D3560042

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

ARM WELDMENT

Batch: *335030*

Handwritten: 12-07-12-17 5

7.0

D3560044

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

ARM WELDMENT

Batch: *335298=1*

335032=4

Handwritten: 12-07-12-17 5

8.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: ~~30.0000~~ Each(s)/Unit Total : ~~180.0000~~ Each(s)

Blind Rivet *32.00*

batch: *M106375*

Handwritten: 3

Handwritten: 12-07-12-17 5

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Drill Rivet holes as per dwg D3562. Touch up alodine

2- Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnabond *****

M105379

A/R Magnabond 6398 Batch: *M104677*

Handwritten: 12-07-12-17 5

Handwritten: 12-07-12-17 5

Handwritten: 12-07-12-17 5

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 5 A1219 (15012)

11.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

2 D2734

Description Batch

End Cap *334485*

Handwritten: 12-07-12-19 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 35822

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M105058

2-Grind end cap welds flush as per Dwg D3562

01.12.19

5

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-12-20

(5)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/12/20

(X5042)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(Touch-up Alodine + pressure wash) M106379

M-1

07-12-20

(5X)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch:

M106332

M-1

07/12/21

(5X)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/12/24 (X5042)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



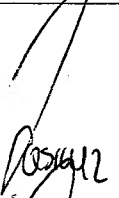
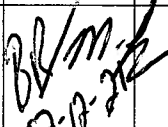



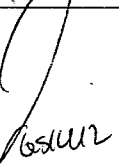
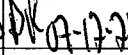




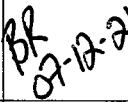



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 01/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/21	# K.D	5 steps had ungrounded, residue left on the side Alodine. From finger prints.		Scuff /leave the powder coat from the affected areas.	 07-12-21	 07/12/21		 07/12/21
		R.C. steps were not cleaned correctly		clean off the magnesium magnesium with thinner.	 07-12-21	 07/12/21		 07/12/21
				Scuff the remaining powder coat and the powder coat as per OS1005.	 07-12-21	 07/12/21		 07/12/21

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Job Number: 35822

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

D 08/01/03

Job Completion



June 2008/1/3 cy

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

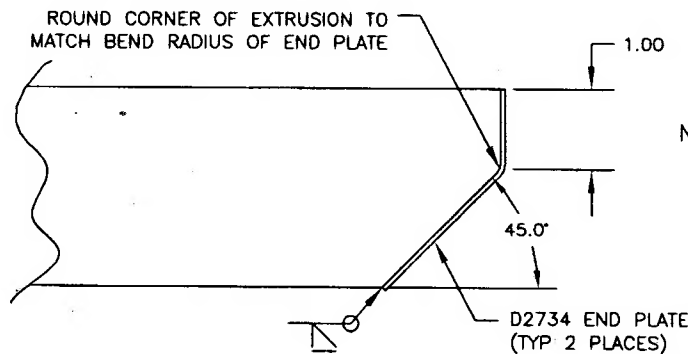
NOTE: Date & initial all entries



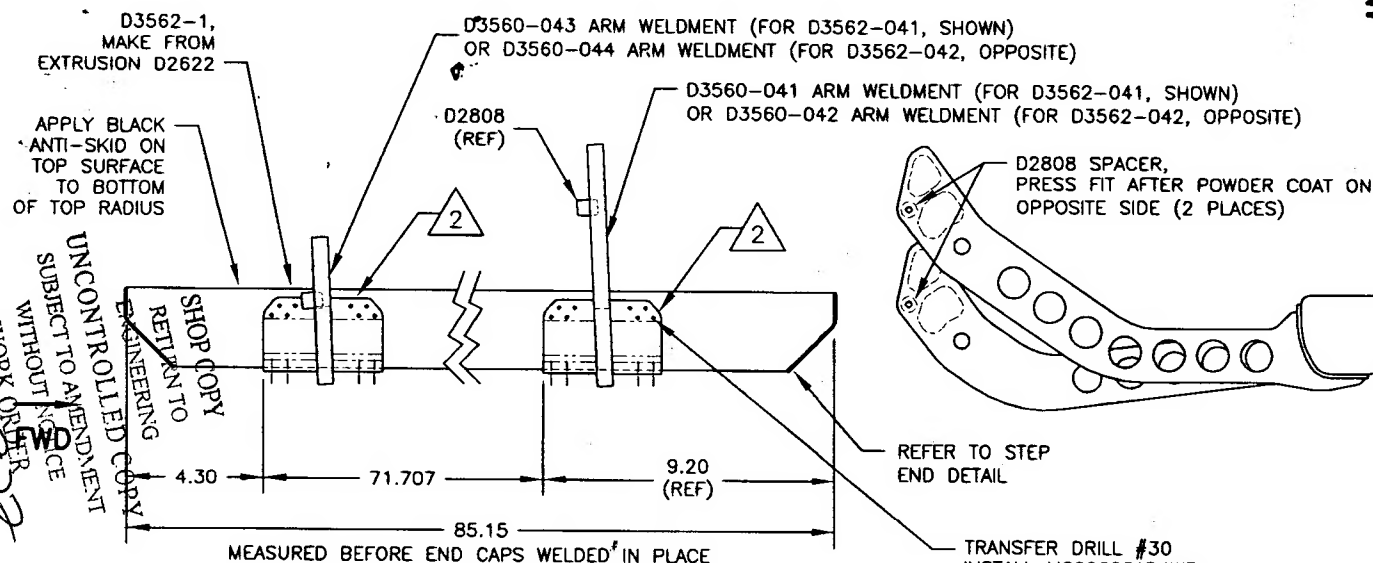
RELEASED
07.06.24-10
07.11.20 DC

UNDER REVIEW

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE



D3562-041 LH STEP ASSEMBLY (SHOWN)
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMESBURY, ONTARIO, CANADA
CHECKED	APPROVED	REV. C
DATE 07.06.19	DRAWING NO. D3562	SHEET 1 OF 1
	TITLE STEP ASSEMBLY	SCALE NTS
A	06.09.26	NEW ISSUE
B	07.01.15	ARMS NOW RIVETED TO STEP
C	07.06.19	NOW MAGBND, ADD D2808, RMV 4 RVTS